

Work Order ID 71455

Monday, July 04, 2011 1:30:06 PM



Page 1

Item ID: D3391-021

Accept



Setup Start



Revision ID:

Item Name: Fwd Tube Assembly

Stop



Start Date: 7/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/19/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 1-07-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3391

Rev H

100



Skidtubes

Skidtubes

Memo

0.00

0.00

1 *B*

11/08/16

110



BENDING MACHINE - SKIDTUBES

CNC Bend 1

CNC Delta 100 Bender

Memo

0.00

0.00

TW 11-08-18

①

120



QC5- Inspect part completeness to step on W/O

QC

Quality Control

Memo

0.00

0.00

DP 11-8-18 *①*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA590 Rev. AA & Dwg D3391 Rev. H
Identify as D3391-1
2-Deburr

JK 11-08-19

①

140



QC2- Inspect parts off machine FAI/FAIB

0.00

JK 11-08-19

QC

Memo

0.00

Quality Control

①

150



CONVENTIONAL MILLING MACHINE

0.00

JK 11/08/23

Mill Conv

Memo

0.00

Conventional Milling Machine

Drill X1 Aft cap as per Dwg D3391 .1875" dia

1

Dart Aerospace Ltd

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Quality Control

170



QC

QC8- Inspect parts - second check

0.00

Quality Control

0.00

0.00

1

1

φ

φ

Dart Aerospace Ltd

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

180

Operation
Description

Skidtubes

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Skidtubes

Skidtubes

Memo

0.00

1-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)
(ONLY DRILL HOLES MARKED "A")

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875"
holes drilled in previous step

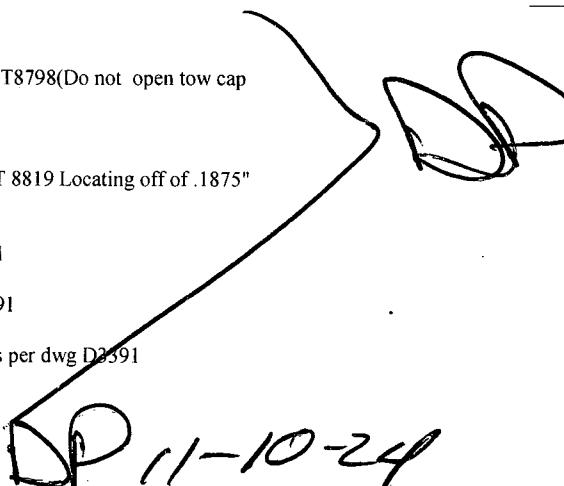
3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5- open float bag holes 0.328" and counter sink as per dwg D3391

6-Deburr & Scribe Batch number Inside aft end.

7-Transfer drill D3391-021 with D3391-023



11-9-20

DP 11-10-24

190



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

O 8 11.10.24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

200



HandFinish

Hand Finishing

Operation
Description

Chemical Conversion Coat per QSI005 4.1

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210



QC

Quality Control

QC3- Inspect Part Finish

0.00

SAP

11-10-25

220



Skidtubes

Skidtubes

0.00

Memo

0.00

1-instal spacers as per dwg D3391

A/R Magnabond 6398 batch: i17870

exp. date: 12-8-30

cure time 12hrs. as per QSI015

2- grind crossbolt flush

3-back drill crossbolt if necessary

DP

11-10-25

DP

11-10-26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230



QC

Quality Control

QCS- Inspect part completeness to step on W/O

0.00

8 u 10/27

0.00

235



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

0.00

Memo

AND REALODINE AS PER PAR09-043

240



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

START TIME: 10:00
OVEN TEMPERATURE: 320 °F
FINISH TIME: 10:30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

1x 6 M u10131

Quality Control

255



Skidtubes

0.00

Skidtubes

Memo

0.00

1x 6 M u10131

Skidtubes

**** install D3591-1 spacer as per DSI9364 and wearplate and gasket as per DWG ****



257



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

M 11/11/01 0

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 7/19/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260

Identify as per dwg & Stock Location: WLO

0.00

D472-742-043/1375563

1

0

M/11/01/13/

Packaging

Memo

0.00

280



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

M/11/01/13/

MF
(1-10-0)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

• Monday, July 04, 2011 1:30:04 PM

Page 1

Work Order ID: 71455



Parent Item: D3391-021



Parent Item Name: Fwd Tube Assembly

Start Date: 7/5/2011

Required Date: 7/19/2011

Comments: IPP A□05.09.13□New issue□ KJ/JLM

KUJLM

IPP B 06.02.10 Dwg rev.D ecn 773 EC

IPP C06.05.02 Added inspections

IPP D 07.03.13 rev F dwg

IPP E 07.11.07 revG dwg ecn1053P EC verified by: DD

EC Verified
verified by: EC

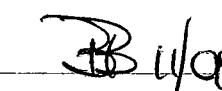
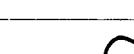
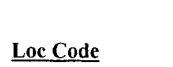
IPP Rev:I ECN 1050 07-11-12 DD Verified by
IPP Rev:G 08-09-08 new process (ecn 08-510) DD

[PP Rev:G 08-09-08] new process (ech 08-310) DD verified by:EC
[PP Rev:H 08-09-10] revH as per dwg. DD verified by:EC

IPP Rev.H 08-09-10 revH as per dwg DD verified by:EC
IPP Rev.I 09-03-02 added hardware EC verified by:

IFF Rev J 09.02.02 added Hardware EC Verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6013-047	Manufactured	No	100	Each	14.0000	1			
Skidtube Material									
D3670-4-200	Manufactured	No	<u>Location</u> LG 	<u>Loc Qty</u> 14 14	<u>Loc Code</u>				
SPACER									
D3401-041	Manufactured	No	<u>Location</u> LG 	<u>Loc Qty</u> 26 26	<u>Loc Code</u>			 	
Tow Cap Assembly									
FP007	Manufactured	No	<u>Location</u> 61505	<u>Loc Qty</u> 2 2	<u>Loc Code</u>				

Dart Aerospace Ltd

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Picklist Print

Page 2

Monday, July 04, 2011 1:30:04 PM

Work Order ID: 71455



Parent Item: D3391-021



Parent Item Name: Fwd Tube Assembly

Start Date: 7/5/2011

Required Date: 7/19/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-13



Manufactured No

255

Each

16.0000

1

1



u10138

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP016

16

B72850

69280

16

x1

D3566-13



Manufactured No

255

Each

26.0000

1

1



u10131

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP

24

1372149

69281

24

x1

FP014

2

1372149

68341

2

x1

AN960C10L

NAS1149C0332

R

Purchased No

255

Each

0.0000

10

10

washer



*



M118354(x10) u10131

AN3C4A



Purchased No

255

Each

2,108.000

10

10

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST350

2108

M118706

117313

2

x10

117688

776

x10

117795

500

x10

117872

22

x10

118012

500

x10

118112

308

x10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
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Parent Item: D3391-021



Parent Item Name: Fwd Tube Assembly

Start Date: 7/5/2011

Required Date: 7/19/2011

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

255

Each

1,122.000

4

4



ML u10131

Phenolic Washer

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	ST074	1096	
	64177	596	
	<u>66821</u>	500	<u>Y4</u>
	ST077	26	
	52505	26	

AELS-1032-130

Purchased No

255

Each

0.0000

2

2



M118966 (x2) ML u10131

INSERT

AELS-1032-225

Purchased No

255

Each

0.0000

10

10



M118694 (x10) ML u10131

INSERT

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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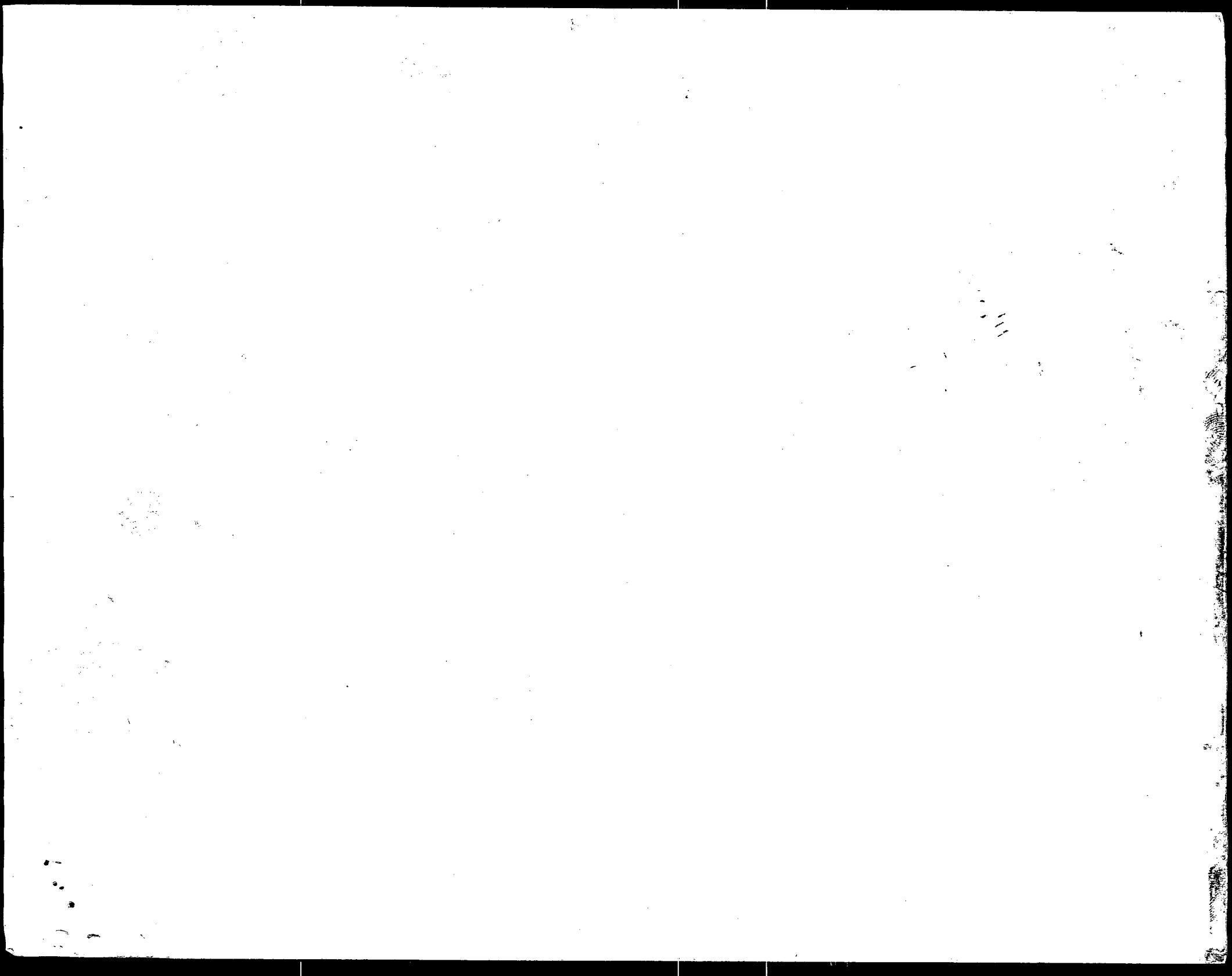
NOTE: Date & initial all entries

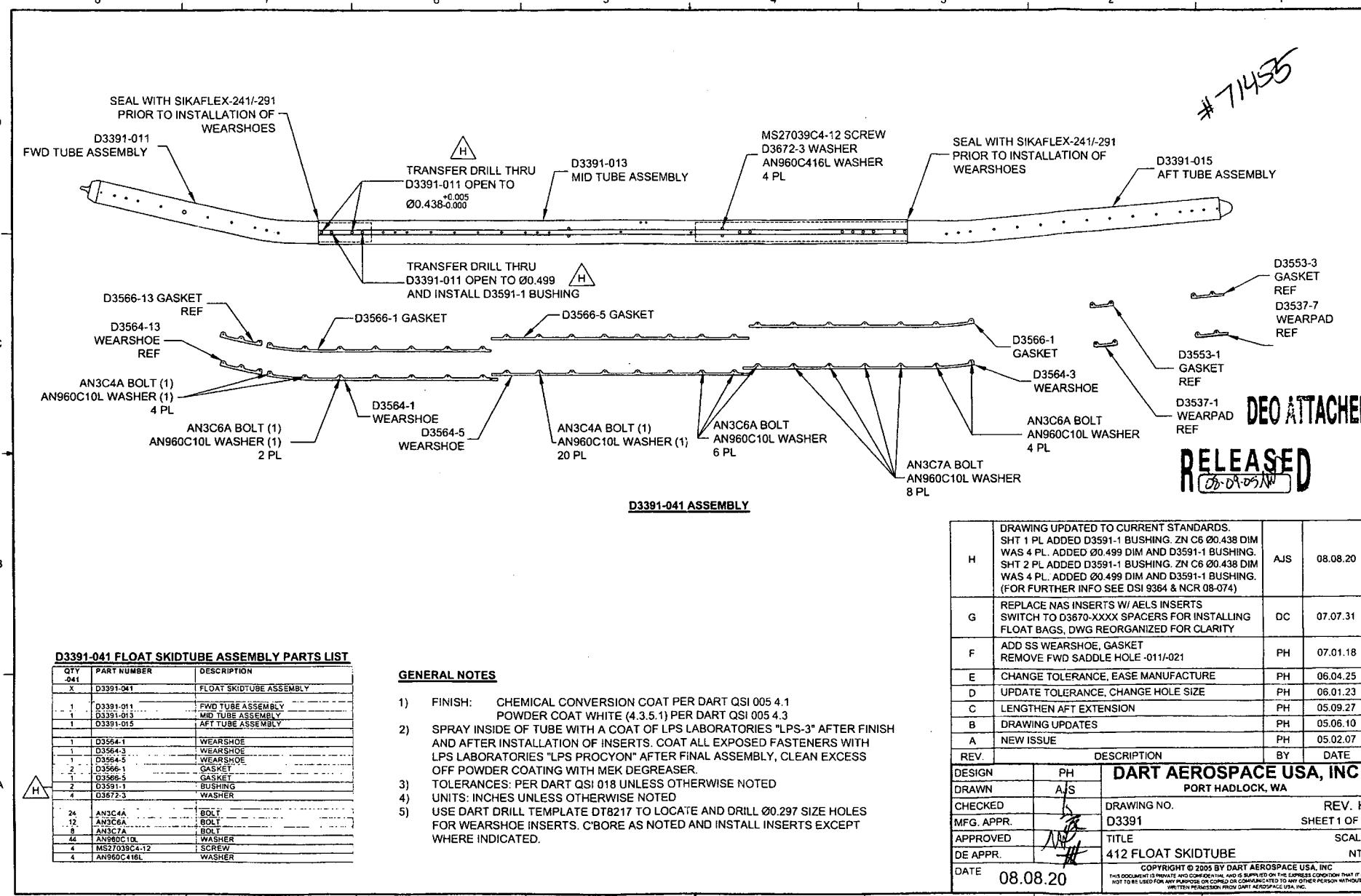
DART AEROSPACE LTD	Work Order:	7455
Description: Fwd Hub	Part Number:	D3391-1
Inspection Dwg: D3391 Rev: H		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	JL	Audited by:	B.A.	Preliminary Approval:	
Date:	11-08-19 11/08/19	Date:	11/08/24	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	





#71455

D3553-3
GASKET
REF
D3537-7
WEARPAD
REF

RELEASED
08-09-05 AM

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKID/TUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
4	D3872-3	WASHER
24	AN93C4A	BOLT
12	AN93C7A	BOLT
44	AN960C10L	BOLT
4	MS27039C4-12	SCREW
4	AN960C16L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL $\varnothing 0.297$ SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DS1 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE-011-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		REV. H	
MFG. APPR.		D3391 SHEET 1 OF 8	
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	INTL
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED EXCEPT BY THE PERSON TO WHOM IT WAS PROVIDED BY DART AEROSPACE USA, INC.	

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Dart Aerospace Ltd

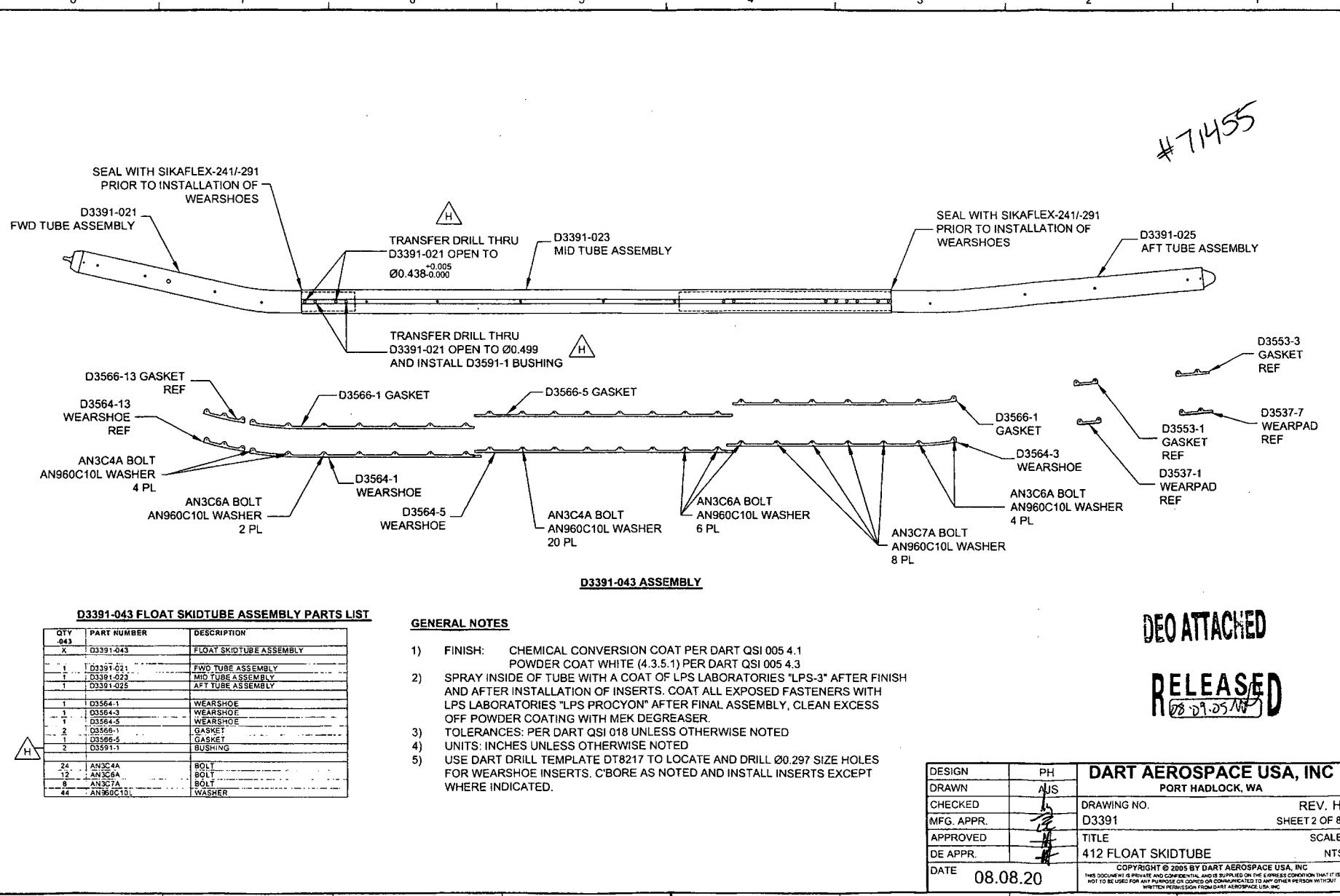
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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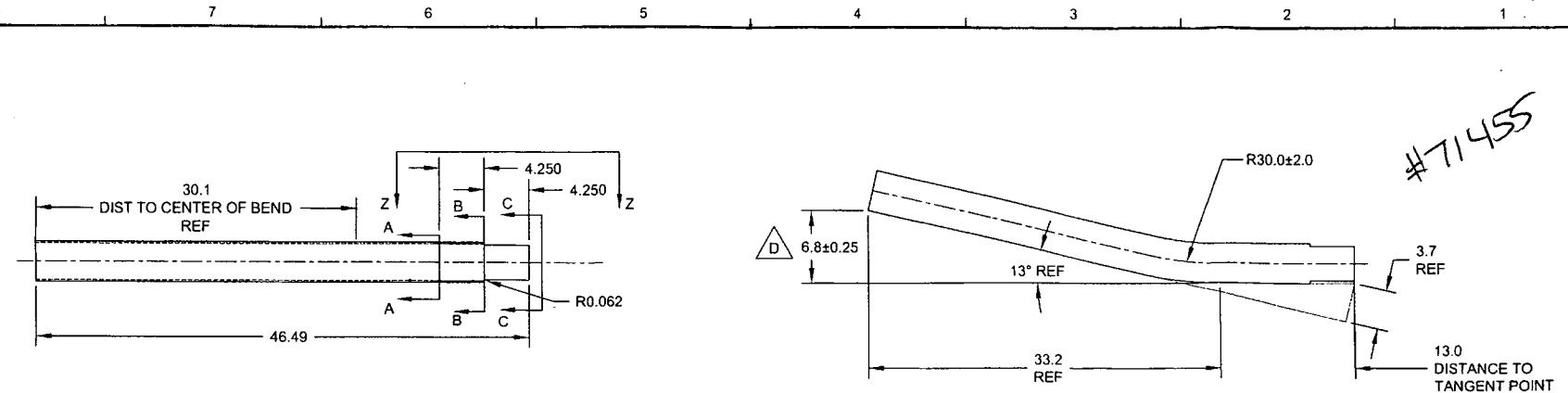
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

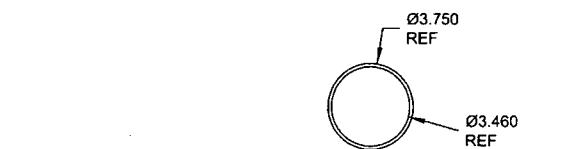
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

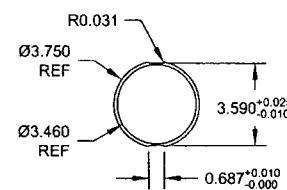
NOTE: Date & initial all entries



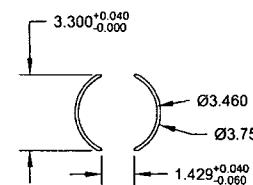
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



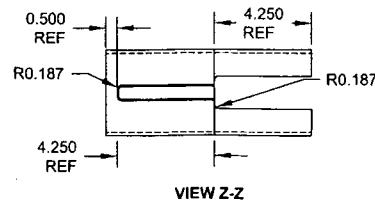
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

#71455

D3391-011-021 BENDING DETAIL
(MAKE FROM D3391-1)

DET ATTACHED

RELEASED
08.08.20

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AUS	PORT HADLOCK, WA	
CHECKED	<i>JW</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>SG</i>	D3391	SHEET 3 OF 8
APPROVED	<i>JW</i>	TITLE	SCALE
DE APPR.	<i>MM</i>	412 FLOAT SKIDTUBE	NTS
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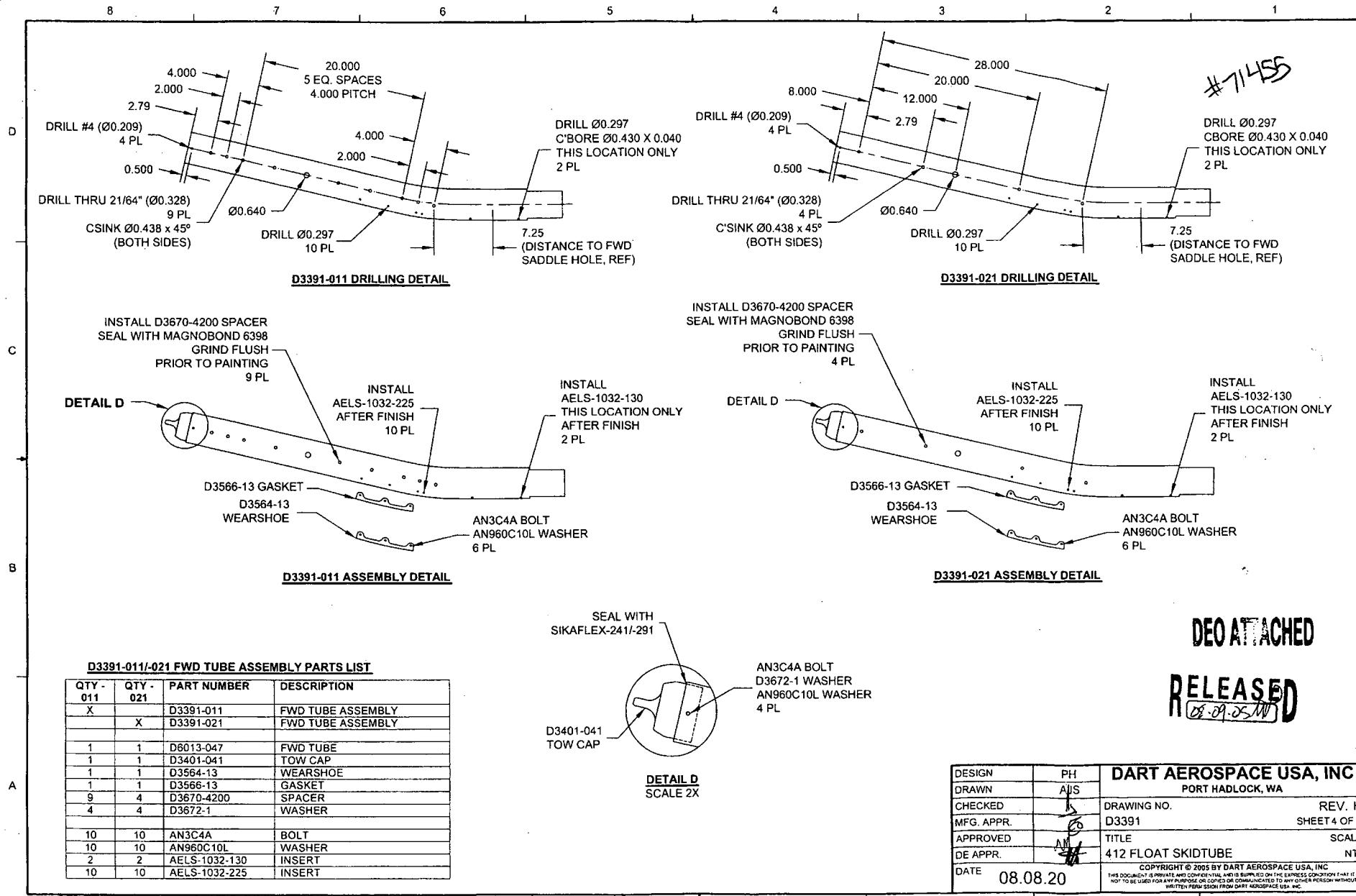
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd

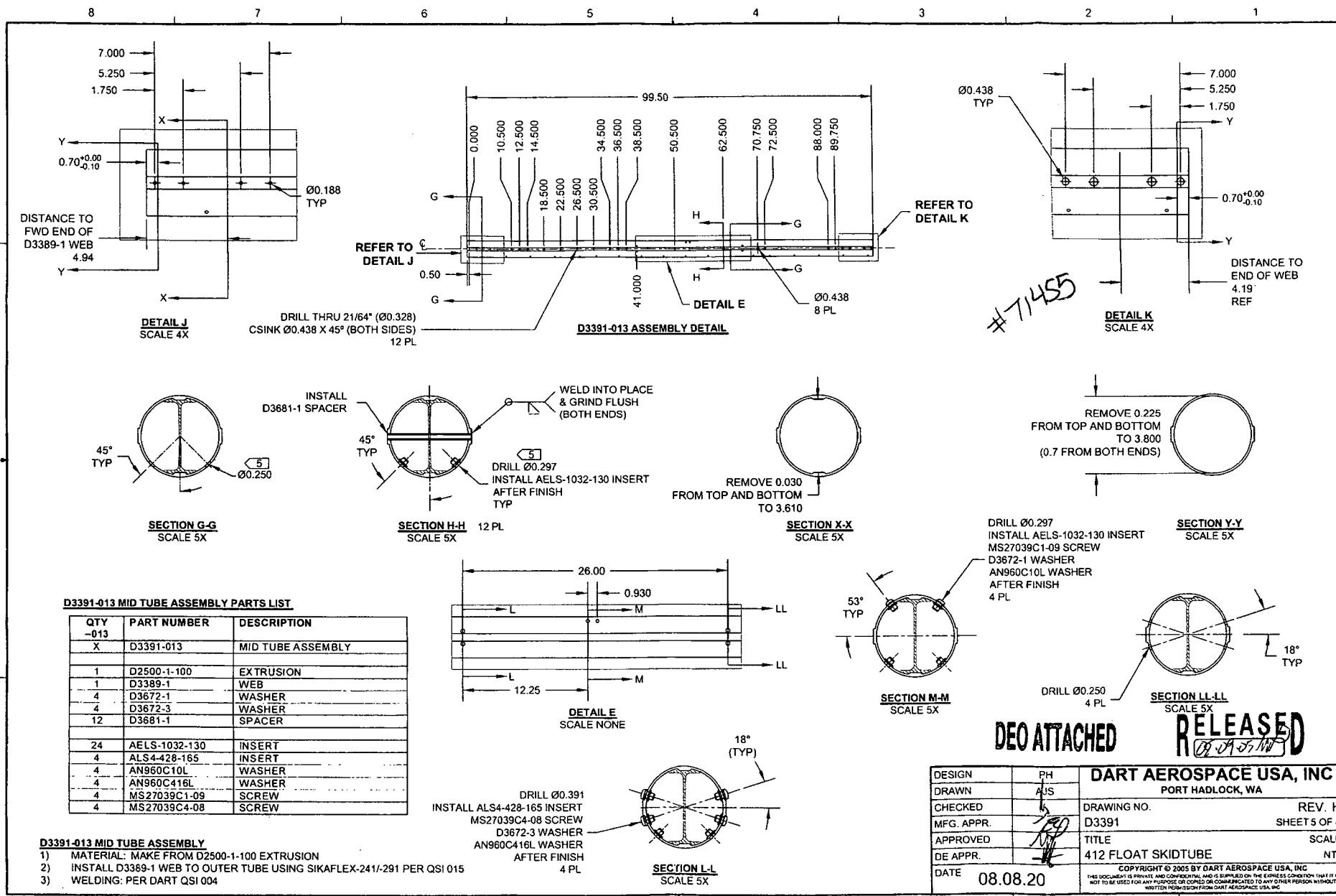
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



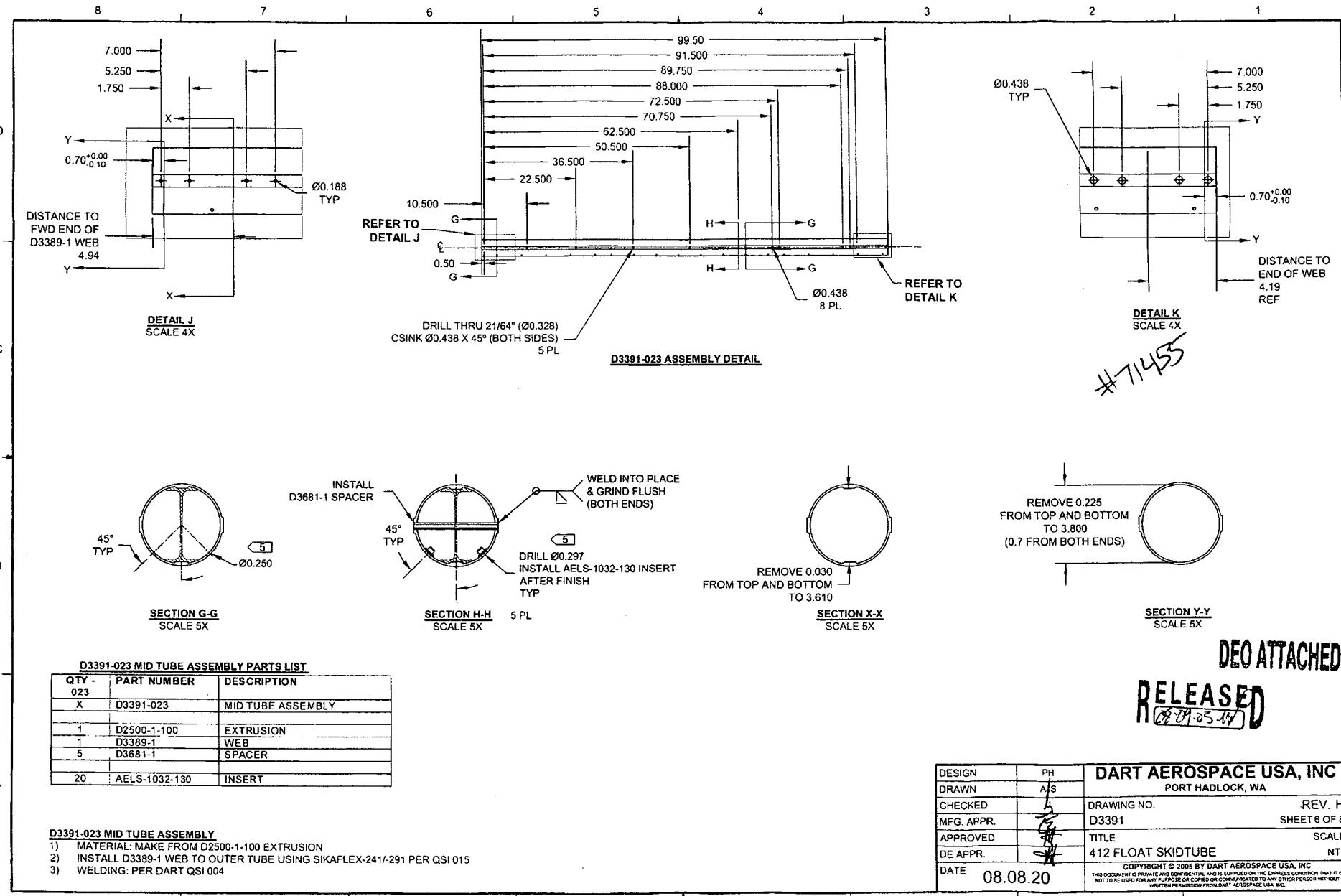
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W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd

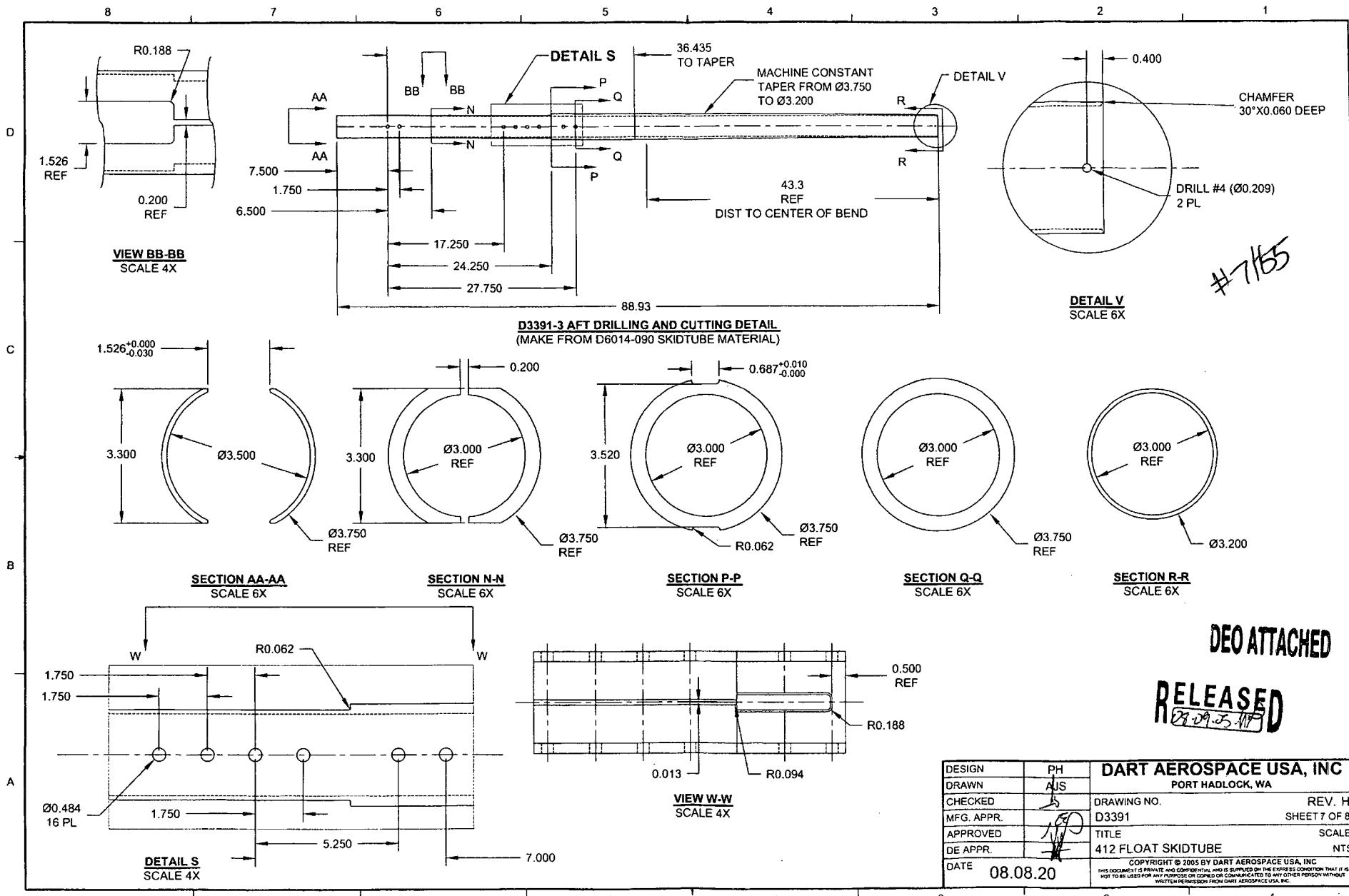
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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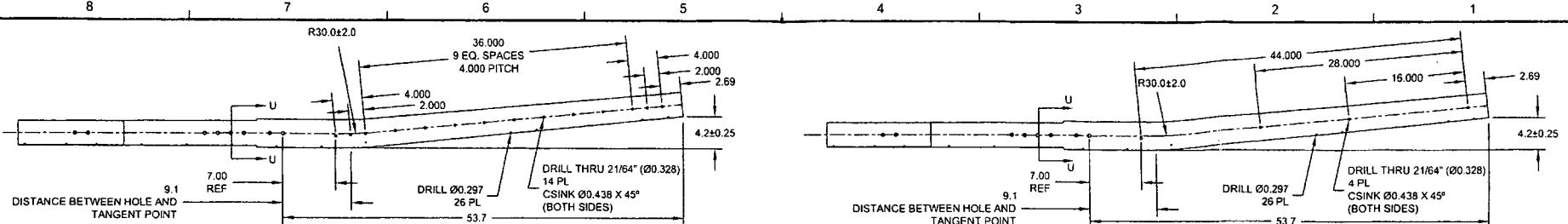
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3391-015 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)

INSTALL D3670-4200 SPACER
SEAL WITH MAGNOBOND 6398
GRIND FLUSH
PRIOR TO PAINTING
14 PL

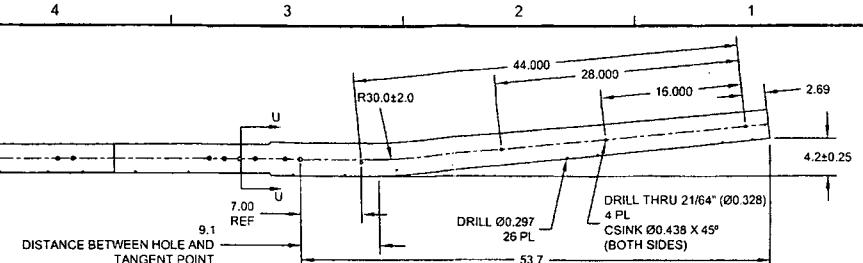
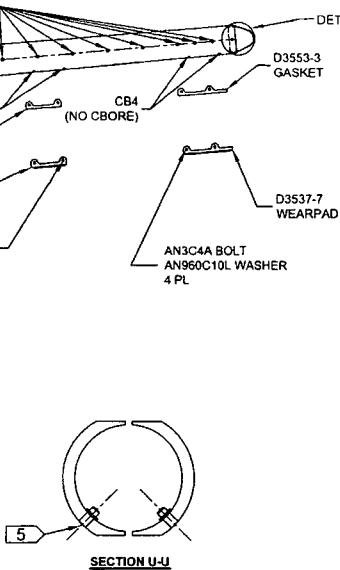
D3391-015 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
X	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
14	14	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
4	4	ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER

CBORE HOLES MARKED CB1-CB4 AS FOLLOWS AND
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

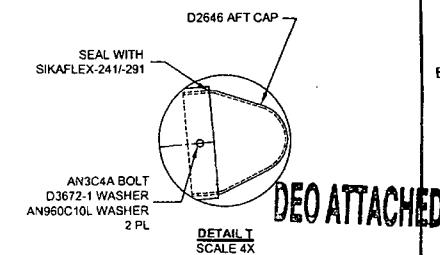
HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130



D3391-025 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)

INSTALL D3670-4200 SPACER
SEAL WITH MAGNOBOND 6398
GRIND FLUSH
PRIOR TO PAINTING
4 PL

D3391-025 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)



RELEASED
08-09-05-10

DESIGN	PH	DART AEROSPACE USA, INC
DRAWN	AJS	PORT HADLOCK, WA
CHECKED		DRAWING NO.
MFG. APPR.		REV. H
APPROVED		D3391
DE APPR.		SHEET 8 OF 8
DATE	08.08.20	TITLE
		SCALE
		412 FLOAT SKIDTUBE
		NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>(P)</i>	CHECKED <i>AA</i>	MFG. APPR. <i>AA</i>	APPROVED <i>MP</i>	DE APPR. <i>MP</i>		
DATE 09/09/23	DATE 09/09/24	DATE 09/09/25	DATE 09/09/30	DATE 09/09/30	DATE 09/09/30	

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.~~ COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
R 2010-02-02

MP

#7145

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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